Work Ord <i>May-27-13 8:41</i>		107		*102	2107*					 	Page 1
Item ID: Revision ID: Item Name:	D4030-041 Long Basket As:	sembly (350)		Accept	*N900	040	100)*	Setup Star	ı VI	S1* S2*
Start Date: Required Date: Reference:		Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:					
Approvals:	Process Plan QC:	: W	Date:	Tooling: SPC (Y/N):		ate:		I	Run Star Sto	1/1	R1* R2*
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Pian Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revis	ion Nbr		*		And the second sequel ()				A . 4	
D4030	C				-				t	J 13	3-7-10
100	, ,	Pick Kit		0.00				f	`		
100 Packaging Packaging		Мето		0.00	*						
:					. 7.						
110		Assemble as per dwg		0.00						4	
110 HandFinish		Memo		0.00			_		9	Bl	13-7-11
Hand Finishing			label plate to size of D408 or label, apply label ****	6 label, use scotchbrite re	d pad to lightly						at .
120		QC5- Inspect part comp	eleteness to step on W/O	0.00				. 1			05 B. 01 - 1
120 QC Quality Control		Memo		0.00					er e carron (servici anno del e . e		(~~8 °

											DQA:	Da	te:	
NCR: Y	'es	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPDATE					
							-				QA Closed:	Da	te:	
Work Orde	, ii.					DISPOSITION			AGAINS	T DE	PARTMENT	/PROCESS		
WOIK OIGE	-					Rework	٦	İ	Skid-tube Crosstube	۰	1	Water Jet		Engineering
Part N	J۸					Scrap	┧ ˈ		Machining Small Fal		Pro	d. Eng. Coor.	\vdash	Quality
	-					Use-as-is	1	i	noforming Finishin	-	4	re/Packaging		Other
NCR N	lo.					Work Order Update	1		Large Fab Composite		1	Supplier	-	
											_			
Root					Descri	iption of work order update		Initial	Action		Sign &			
Cause		Date	Step	Qty		or Non-conformance	Cr	nief Eng	Description		Date	Verificatio	n	QC Inspector
Doc/Data														
Equip/Tooling														
Operator														
Material	_													
Setup	Щ													
Other	Ш													
Process	Ш													
Supplier	\vdash													
Training	Н			1			Ì							
Unapproved			İ	<u></u>	<u> </u>			TCATE	CORV		I			<u> </u>
1	6	·					AUI	LT CATE	GURT					
Landi						General Bend		Grain			Ovalized			Pressure/Forced
	${f o}$	Bending	at Canaa	ntrin ta	~ -	BOM/Route	\vdash	4	ro	\vdash	Over/Under	tolorance	\vdash	Temperature/Cure
	${f H}$	Centre No Cracks	or conce	וונזוכ נס	U/3 -	Broken/Damaged	\vdash	Hardwa	re ion Incomplete	\vdash	Part Incorre		\vdash	Weld
	${f H}$	Crushed/	Crimned		-	Burrs	-	4 .	ions Incomplete/Unclear	\vdash	Part Lost/M		\vdash	Wrong Stock Pulled
	Н	Cuffs	Cittipea		-	Contamination	\vdash	Mainte	•	\vdash	Part Moved	_		Triong Stock i diled

Mislabeled

Out of Calibration
Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio

Work Orc May-27-13 8:		02107		**	102	107*							Page 2	!
Item ID: Revision ID: Item Name:	D4030-041	t Assembly (350)		Accept		*N900	0040	100)*	Setup	Start Stop	*N *N	S1* S2*	
Start Date: Required Date Reference:	5/27/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*			Cust Item Customer:							.7/	
Approvals:		Plan:	Date:	Tooling: SPC (Y/I			oate:			Run	Start Stop	I/I	R1* R2*	:
Sequence ID/ Work Center 130 *120* Packaging		Operation Description Identify as per dwg & St Memo	ock Location:	Set U _I Run F 0.00 0.00		Tool ID	Tool #	Plan Code	Accep Qty	t Re	•	Reject Number	Insp. Stamp	!(
*140 *140* QC Quality Control		QC21- Final Inspection Memo	- Work Order Release	0.00						_ [=	3/7	/16 M	F 3-7-13	j

NCR:	Yes	1	No

Date:

DQA:

NCR: Ye	es / No				WORK ORDER NON-	CONF	ORN	NANCE / UPDATE		QA Closed:	Date:	÷
										QA Ciuseu.	Date.	
Work Order	:.				DISPOSITION			AGAII	NST DE	PARTMENT/	PROCESS	
WOIR OIGCI	•				Rework	7		Skid-tube Crosst	ube		Water Jet	Engineering
Part No) .				Scrap	1		Machining Small		Proc	d. Eng. Coor.	Quality
	<u></u>				Use-as-is	┪┃.		oforming Finish	hing	Rec/Stor	e/Packaging	Other
NCR No	0.				Work Order Update	1		Large Fab Compo	site		Supplier	
		•										
Root					iption of work order update	Ini	i	Action		Sign &		
Cause	Date	Step	Qty	•	or Non-conformance	Chie	f Eng	Description		Date	Verification	QC Inspector
oc/Data						1						
quip/Tooling	_				•		ļ					
perator												
Material	_											
etup	_						,,					
Other	_				ه خر	1 .	.					
rocess						1						
Supplier												
raining						1						
Jnapproved		<u> </u>			·····							
· · · · · · · · · · · · · · · · · · ·			,		F	AULT	CATE	GORY				
Landin	g Gear			_	General				_	1		٦ -
L	Bending			_	Bend	ЩG	irain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	_BOM/Route	Н	ardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	∐lr	rspecti	on Incomplete		Part Incorred	it	Weld
	Crushed/	'Crimped			Burrs	L Ir	nstruct	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	∐^	/lainte	nance		Part Moved		
	Heat Trea	at			Countersink	^	1islabe	led		Positioned V	Vrong	_
	Inspectio	n Strip in	Tube		Cut Too Short	□	/lisreac	1		Power Loss/	Surge	Other
	Ripples in	n Bend			Drill Holes		ffset					
	Torque V	Vaves in I	Extrusio	n [Drawing		ut of (Calibration				
	Turning 9	Sequence	!		Finish		ot of S	Sequence				
Wave/Twist in Tube Folio							utside	Dimensions				

Picklist Print

May-27-13 8:41:18 AM

Work Order ID:

102107

Parent Item:

D4030-041

Parent Item Name:

Long Basket Assembly (350)

Start Date: 5/27/13

Required Date: 6/05/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

10.04.20 verified by:EC

IPP Rev:A new issue DD 10.03.23 verified by:EC

IPP Rev:B as per dwg revB DD IPP Rev:C as per dwg revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measur	Qty on e Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4086-200 Placard, Max Load		Manufactured	No				Each	21.0000		1	795		
,				Location		Loc Qty	Ţ	Loc Code					
				ST093		21							
				100	0556	12							
				886		1							
				962		1				0.60			
				985	519	7			_7	8519			
D2530		Manufactured	No			100	Each	9.0000	1	σ_{α}^{-1}	-ys		
Handle Weldment									/-	8_0_1_0	- yo	The state of the state of	
				Location		Loc Oty	<u> 1</u>	Loc Code					
				ST205		1							
				870	086	1							
				ST255		8							
ξ				100)263	8							
D2535		Manufactured	No			100	Each	22.0000	2	2			
Spring									<u> </u>	······································	- 27	5	
				Location		Loc Qty]	Loc Code					
				ST011		22							
				962	248	22			96	248			
D2537		Manufactured	No			100	Each	110.0000	2	2		1	2 10
Bushing											~ 31	15-0	1-10
				Location		Loc Oty	<u>]</u>	Loc Code					
•				ST008		24							
				990)11	24							
				ST011		86							
				100)454	42							
				947		20				1/10/			
				984	126	24			95	3426			

											DQA:	Dat	te: _	· .
NCR: Y	es/	/ No				WORK ORDER NON-C	O N	NFORM	MANCE / UPI	DATE		_		
											QA Closed:	Dat	te:	
Work Orde	è.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
WOIK OIGE						Rework			Skid-tube	Crosstube	1	Water Jet		Engineering
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.		Quality
						Use-as-is			noforming	Finishing	Rec/Sto	re/Packaging		Other
NCR N	io					Work Order Update			Large Fab	Composite]	Supplier		
Root					Descri	ption of work order update		nitial	Act	tion	Sign &			
Cause		Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	٦	QC Inspector
Doc/Data														
Equip/Tooling														
Operator	Ш												l	
Material	Ш					•								
Setup	Ш										ļ			
Other	Ш			·			İ							
Process	Ш													
Supplier	Ш		į											
Training	Ш				,									
Unapproved			<u> </u>											
							AUL	T CATE	GORY		,			
Landi	ng G	ear			_	General		•			- 1	,		ī
	Ш	Bending				Bend		Grain			Ovalized	ļ		Pressure/Forced
		Centre No	ot Concei	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance		Temperature/Cure
	Ш	Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct		Weld
	\square	Crushed/	Crimped			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/Mi	issing		Wrong Stock Pulled
		Cuffs		-		Contamination		Mainte	enance		Part Moved			
		Heat Trea	ıt			Countersink		Mislabe	eled		Positioned V	Vrong		•
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	t		Power Loss/	Surge		Other
		Ripples in	Bend			Drill Holes	1	Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

May-27-13 8:41:18 AM

Work Order ID: Parent Item:	102107 D4030-041	(250)						Date: 5/27/13	3	Required Date: 6/05/13
Parent Item Name:	Long Basket A							t Qty: 1.00		Required Qty: 1.00
D3913-041 Long Basket Base Asset	mby, 350	Manufactured	No	102108	100	Each	1.0000	$\rightarrow l$	1	Bl 13-710.
			٠	Location	Loc Qty		Loc Code			
				FP	1					
				100171	1			····		4.4
D3914-041 Long Basket Lid Assem	ably (350)	Manufactured	No	93902	100	Each	0000.1	1	1	BL 13-7-10.
				Location	Loc Qty		Loc Code			
				GA	1					
				100179	1					
D3917-3 Washer		Manufactured	No		100	Each	112.0000	6 jo :	2472	~ yB
				Location	Loc Qty		Loc Code			V
				ST072	112					
				100397	82					
				92514	1					
D2052 2			N.	97710	100		42,0000			
D3953-3 Gas Spring Stud, Lid		Manufactured	No		100	Each	43.0000	2	2	-33
Oas Spring Stud, Liu				Lastin	I O+-		L. C. J.	•	2	
	•			Location	Loc Qty		Loc Code			
				GA 87592	1					
		,		ST075	28					
				100485	28			100	485	
				ST076	14			700		
				88494	14					
D3953-7		Manufactured	No		100	Each	63.0000	2	2	
Spring Spacer		1,14114141414						·		gs 13-07-10
				Location	Loc Qty		Loc Code			•
				ST076	63					
				100414	26					
			•	94669	13				- 1: <i>-</i>	•
				99148	24			-7	9148	
May-27-13 8:41:1	9 414			Cl	Packet Print					Page

NCR: Y	es / No				WORK ORDER NON-C	ONF	ORN	AANCE / UPD	DATE	QA Closed:	Date	e:
Work Orde	r:				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part N	0				Rework Scrap		N	Skid-tube Aachining	Crosstube Small Fab	4	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	0				Use-as-is Work Order Update]]		oforming Large Fab	FinishingComposite	Rec/Stor	e/Packaging Supplier	Other
Root				Descri	ption of work order update	Init	tial	Act	ion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief	f Eng	Descr	iption	Date	Verification	QC Inspector
Ooc/Data quip/Tooling				,			;					
perator							İ					
//aterial											!	
etup												
Other			ļ									
rocess												
upplier												
raining		i i				Ì					i	
Inapproved										<u> </u>		
					F	AULT (CATE	GORY				
Landin	g Gear				General					=	_	
	Bending				Bend	G	rain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to (o/s	BOM/Route	Шн	ardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	∐ In	specti	on Incomplete		Part Incorred	ct	Weld
[Crushed/	Crimped		L	Burrs	∐ in	struct	ions Incomplete/U	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	\square^{\vee}	lainte	nance	<u></u>	Part Moved		
	Heat Trea	at			Countersink	Шм	lislabe	led	L_	Positioned V	Vrong	
[Inspectio	n Strip in	Tube		Cut Too Short	Шм	lisread	I		Power Loss/	Surge	Other
	Ripples in	n Bend			Drill Holes	Шο	ffset					
	Torque V	Vaves in I	Extrusion	າ [Drawing		ut of C	Calibration				
	Turning Sequence			[Finish	0	ut of S	Sequence				•

Outside Dimensions

Date:

Wave/Twist in Tube

Picklist Print
-May-27-13 8:41:18 AM

Work Order ID: Parent Item: Parent Item Name:	102107 D4030-041 Long Basket Assembly (350)						Date: 5/27/13 t Qty: 1.00		Required Date: 6/05/13 Required Qty: 1.00	
D3953-9	Manufactured	No		100	Each	43.0000	2	2	40	. ;
Gas Spring Washer								* **		
			Location	Loc Oty		Loc Code			•	
			ST076	43			OF.	111		
			95127	43		•• •••		127		
D3953-17	Manufactured	No		100	Each	22.0000	2	2	19	
Gas Spring Spacer										
			Location	Loc Qty		Loc Code				
			ST076	22						
6 · · · · · · · · · · · · · · · · · · ·			97100 97696	2 20			-6.	1696		
D3953-19	Manufactured	No	97090	100	Each	6.0000	1	1 6 7 6 1		
Gas Spring Bracket	Manufactured	140		100	Lacii	0.0000	100	234 1	18	
			Location	Loc Qty		Loc Code	·	•	0	
			ST077	6						
			97691	6						
D3953-21	Manufactured	No		100	Each	36.0000	1	1		
Gas Spring Bracket									J A	
A			Location	Loc Oty		Loc Code			0	
			ST075	8						
			97714	8						
			ST077	28						
The state of the s			100404	28			100	404		
D3969-3	Manufactured	No		100	Each	25.0000	1	1		-7 10
Spring (Basket Lid)									178 13-0	07-10
			Location	Loc Oty		Loc Code				
			ST262	23						
	•		91844	3						
			99623	20			996	33		!
			ST272	2						

97050

											DQA:	Date:	
NCR: Y	'es /	No				WORK ORDER NON-C	ON	IFORM	MANCE / UPDA		QA Closed:	Date:	
						<u> </u>				<u></u>			
Work Orde	ıř.					DISPOSITION	ı			AGAINST DEF	PARTMENT	/PROCESS	
Part N	lo			-		Rework Scrap Use-as-is Work Order Update		Thern	Machining noforming	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
						· h	'			· —			
Root					Descri	ption of work order update	ı	nitial	Action	٦	Sign &		
Cause	D	ate	Step	Qty	(or Non-conformance	Ch	ief Eng	Descript	tion	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator													
Material													
Setup		1					1			Ì			
Other						•		•					
Process		l											
Supplier					ļ					1			
Training										ł			
Unapproved					-		<u> </u>						
						<u> </u>	AUL	T CATE	GORY				
Landi	ng Gear					General		1					7
	Ben	ding				Bend	Ш	Grain			Ovalized	_	Pressure/Forced
	Cen	tre Not	Concer	ntric to	o/s	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure
	Cracks			Broken/Damaged		Inspect	ion Incomplete	<u> </u>	Part Incorre		Weld		
	Cru	shed/Cr	rimped		_	Burrs		Instruct	cions Incomplete/Unc		Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuf	fs				Contamination		Mainte	enance		Part Moved		
	Heat Treat				Countersink	1	Mislabe	eled		Positioned V	Vrong		

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

May-27-13 8:41:19 AM

Work Order ID:	102107							0	5/05/12		D
Parent Item:	D4030-041	1 (250)							Date: 5/27/13		Required Date: 6/05/13
Parent Item Name:	Long Basket Assemb	oly (350)						Start	Qty: 1.00		Required Qty: 1.00
AN3-14A Bolt		Purchased	No			100	Each	141.0000	4	4	-JB
				Locatio	<u>n</u>	Loc Qty		Loc Code			V
				ST351		100					
					m125709	100			125	709	
				ST512		41					
					123759	41					
AN3-16A Bolt		Purchased	No			100	Each	74.0000	2	95	78
				Locatio	<u>n</u>	Loc Qty		Loc Code			
				GA	_	47					
					117441	47					
				ST352		27			_		
					122407	8					
					123900	19					
AN5-17A Bolt		Purchased	No			100	Each	246.0000	126	176	- J-B
				Locatio	<u>n</u>	Loc Oty		Loc Code			•
				GA		36					
					117872	36					
				ST337		60					
					124215	50					
					124805	10					
				ST514		150					
					125388	150					
AN4-12 Bolt		Purchased	No			100	Each	91.0000	3	3	79 13-07-10
				Locatio	<u>n</u>	Loc Oty		Loc Code			•
				ST356		91					
					124805	41			1248	05	
					m125709	50					

												DQA:	D	ate:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE			_		
											_	QA Closed:	D	ate:	
Work Orde	or.					DISPOSITION				AGAINST D	EΙ	PARTMENT	/PROCESS		
WOIK OIG	٠٠٠.					Rework	7		Skid-tube	Crosstube	٦	Water Jet			Engineering
Part N	No.					Scrap	1 '	1	Machining	Small Fab				-	Quality
	•								Finishing	٦	Rec/Sto	re/Packaging	3	Other	
NCR I	No.					Work Order Update]		Large Fab	Composite			Supplie	r	
					·						_				,
Root					1	iption of work order update	1	Initial	ł	tion		Sign &			
Cause		Date	Step	Qty		or Non-conformance	Cr	nief Eng	Desc	ription		Date	Verification	on_	QC Inspector
Doc/Data															
Equip/Tooling															
Operator											ı				ļ
Material															Į
Setup															
Other							1				-				
Process			1				ļ				ŀ				
Supplier				1							ŀ				
Training									1		ŀ				
Unapproved				<u> </u>	<u> </u>						_				
							AUI	LT CATE	GORY				· · · · · · · · · · · · · · · · · · ·		
Landi	ing (Gear			م	General	_	7		F	_	1		_	7
	L	Bending			L	Bend	\perp	Grain		-	_	Ovalized			Pressure/Forced
1	\vdash	Centre N	ot Conce	ntric to	o/s	BOM/Route	<u>_</u>	Hardwa		_		Over/Under		<u>_</u>	Temperature/Cure
		Cracks				Broken/Damaged	L	4	ion Incomplete	-	_	Part Incorre		\perp	Weld
		Crushed/	'Crimped			Burrs		Instruct	tions Incomplete/	/Unclear	_	Part Lost/M	issing		Wrong Stock Pulled
Cuffs				Contamination	Maintenance				Part Moved						

Mislabeled Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio May-27-13 8:41:19 AM

Work Order ID:	102107										
Parent Item:	D4030-041						Start D	ate: 5/27/13		Required Date	e: 6/05/13
Parent Item Name:	Long Basket Assembly (350)						Start (Qty: 1.00		Required Qt	1.00
AN310-4 NUT	Purchase	i No			100	Each	130.0000	3	3	JB	
			Location		Loc Oty		Loc Code			V	
•			ST342		130						
			122	800	2						
			1243	221	28						
			M12	5716	50						
			M12	5752	50			125	758		
AN310C4 Nut	Purchase	d No			100	Each	55.0000	2	2	1 45	
			Location		Loc Qty		Loc Code			0	
			ST342		55						
			123	331	2						
			124		53			124	1221		
MS21042L3	Purchase	d No			100	Each	3,253.0000			_	<u>.</u> .
Nut								.12	6036	- gB	13-07-1
			Location		Loc Oty		Loc Code			•	
			FP001		3						
			122	41	3						
			GA		18						
			122	152	18						
			ST314		268						
			117	385	32						
			119		55						
			119		138						
			123		43						
			ST506		2964			_			
			123	900	954						
	•		124		2010						

										DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	O	NFORN	/ANCE / UP	DATE		_	• •
										QA Closed:	Date:	
Work Orde	.				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Order					Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	0.				Scrap		r	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is]]	Therm	oforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	o				Work Order Update			Large Fab	Composite		Supplier	
- Doot	<u> </u>	<u></u>		Doscri	ption of work order update		nitial	۸	ction	Sign &		
Root	Date	Step	Qty		or Non-conformance		ief Eng		cription	Date	Verification	QC Inspector
Cause Doc/Data	Date	Step	Qty		or Non-comormance		iei ciig	Desc	ription	Date	Vermeation	QC IIISPECTOI
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Supplier]										
Training		ŀ										
Unapproved												
<u>,</u>		<u>.1</u>	<u> </u>	<u> </u>	F	AUL	T CATE	GORY			-	
Landin	ng Gear				General							
	Bending				Bend .		Grain			Ovalized		Pressure/Forced
[Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped			Burrs		Instruct	ions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
Ì	Cuffs				Contamination		Mainte	nance		Part Moved		
	Heat Trea	at			Countersink		Mislabe	led		Positioned \	Wrong	_
<u> </u>			Cut Too Short	Misread				Power Loss/	/Surge	Other		

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Picklist Print

May-27-13 8:41:19 AM

Page 6

Work Order ID: Parent Item: Parent Item Name:	102107 D4030-041 Long Basket Asset	mbly (350)						Pate: 5/27/13 Qty: 1.00		Required Dat	
MS21042L5 Nut		Purchased	No		100	Each	2,049.0000	4	4	- 85_	
	·			Location	Loc Oty		Loc Code				
				ST314	1000						
				125654	1000			1256	54		
				ST506	49						
				123900	49			<u> </u>			
				st507	1000						
				125535	1000						
MS24665-151 Cotter Pin		Purchased	No		100	Each	284.0000	3	3	73	P.L. 4224
				Location	Loc Qty		Loc Code				
				GA	28						
				17566	28						
				ST323	256						
				122802	20						
				124859	36			105	7 1/		
34034445 3 00				125646	200	г,	100 0000	135			
MS24665-300		Purchased	No		100	Each	199.0000	2	2	2.0	13-071
Cotter Pin				2				12 - 12 - 12 - 12 - 12 - 12 - 12 - 12 -	***		
				Location	Loc Qty		Loc Code				
				GA	37						
				118234	37						
				ST299	162			12115	KI	*	
				124555	162			1949	J		•

NCR: Y	'es	/ No				WORK ORDER NON-	CO	VFORI	MANCE / UPI	DATE			•	
											QA Closed	Da1	e:	
Work Orde	. ن					DISPOSITION				AGAINST DI	PARTMENT	/PROCESS		
Part N	_					Rework Scrap Use-as-is		ı	Skid-tube Machining Moforming	Crosstube Small Fab Finishing	-	Water Jet od. Eng. Coor. re/Packaging		Engineering Quality Other
NCR N	اo					Work Order Update]	meni	Large Fab	Composite] Rec/std	Supplier		
Root					Descri	ption of work order update	T	nitial	Act	ion	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	1	QC Inspector
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Landi	ng G	iear				General		_			_	•		•
		Bending				Bend		Grain			Ovalized			Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route	L	Hardwa	ire		Over/Unde	r tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete	L	Part Incorre	ect		Weld
		Crushed/0	Crimped			Burrs	L	Instruct	ions Incomplete/l	Jnclear	Part Lost/N	lissing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance		Part Moved	I		
		Heat Trea	ıt			Countersink		Mislabe	eled		Positioned	Wrong		•
		Inspection	n Strip in	Tube		Cut Too Short		Misrea	t		Power Loss	/Surge		Other
	Ripples in Bend					Drill Holes		Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

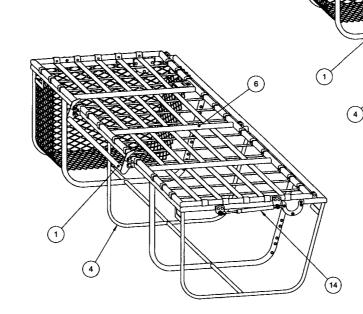
May-27-13 8:41:19 AM

Work Order ID:	102107								
Parent Item:	D4030-041					Start D	ate: 5/27/13		Required Date: 6/05/13
Parent Item Name:	Long Basket Assembly (350)					Start (Qty: 1.00		Required Qty: 1.00
NAS1149F0432P Washer	Purchased	No		100	Each	1,360.0000	6	6	70
			Location	Loc Qty		Loc Code			
			ST295	1360					
			122151	2					
			123522	4					
			123900	32					
			124580	22					
			124859	300			14 -	2 /6	
			125268	1000			193	268	
NAS1149F0563P Washer	Purchased	No		100	Each	688.0000	4	4	133
			Location	Loc Oty		Loc Code			,
			ST295	688					
			121350	688			1213	350	
NAS1149F0332P WASHER	Purchased	No		100	Each	12,498.000	8	8	198
			Location	Loc Qty		Loc Code			•
			GA	182					
			122063	182					
			ST294	158					
			122063	158					
			ST295	3			_		
			123352	3					
			st510	7155			-		
			123900	7155					
			ST510a	5000			1239	(00)	
			125646	5000					
NAS1149C0432R	D 1. 1	No	123010	100	Each	1,314.0000	2	2	✓
	Purchased	140		100	Lacii	1,314.0000	2	2	JJ 13-07-
Washer			_						P
			Location	Loc Qty		Loc Code			
			ST292	1314			-		
			119124	6			144	11171	
			122441	1308			122	1441	
May-27-13 8:41:19	9 AM		Shop I	Packet Print					Page

										DQA:	Date:	
NCR: Y	'es	/ No				WORK ORDER NON-C	ONFOR	MANCE / UP		QA Closed:	Date:	
Work Orde	ıř.				·	DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No. NCR No. Root Desc						Rework Scrap Use-as-is Work Order Update	Ther	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	Initial	Ad	ction	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Chief En	g Des	cription	Date	Verification	QC Inspector
Doc/Data							ļ) 		
Equip/Tooling							Ì					
Operator												
Material												
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Other												
Process												
Supplier			ĺ					1				
Training	П											
Unapproved												
						F	AULT CAT	EGORY				

			FAU	LT CATEGORY		
Landin	g Gear	General			 _	
ſ	Bending	Bend		Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware	Over/Under tolerance	Temperature/Cure
ſ	Cracks	Broken/Damaged	Г	Inspection Incomplete	Part Incorrect	Weld
Ī	Crushed/Crimped	Burrs		Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination		Maintenance	Part Moved	
	Heat Treat	Countersink		Mislabeled	Positioned Wrong	
	Inspection Strip in Tube	Cut Too Short		Misread	Power Loss/Surge	Other
Ī	Ripples in Bend	Drill Holes		Offset		
Ī	Torque Waves in Extrusion	Drawing	[.	Out of Calibration		
	Turning Sequence	Finish		Out of Sequence		
Ī	Wave/Twist in Tube	Folio		Outside Dimensions		

*	ÍTEM	QTY -041	QTY -043	P/N	DESCRIPTION	Γ
3		Х		D4030-041	LONG BASKET ASSY (350)	
٥	:	- 1	Х	D4030-043	LONG BASKET ASSY, LIGHT LID (350)	
	1	- 1	1	D2530	HANDLE WELDMENT	
.	2	.2	2	D2535	SPRING	
Š	3	2	2	D2537	BUSHING	12
	- 4	11	1	D3913-041	LONG BASKET BASE ASSY (350)]
	5	<u>'</u>		_D3914-041	LONG BASKET LID ASSY (350)	_
	. 6	4	1	D3915-041	LIGHT LID ASSY-LONG BASKET	
. !	_7:	i 6	6	D3917-3	WASHER	}
	8	. 2	2	D3953-3	GAS SPRING STUD, LID	
	9	₹2	2	D3953-7	GAS SPRING SPACER	
1	10	本2	2	D3953-9	GAS SPRING WASHER	
	11	L2	2	D3953-17	GAS SPRING SPACER	
	12	₹1	1	D3953-19	GAS SPRING BRACKET	١
	13 -	£1	1	D3953-21	GAS SPRING BRACKET	ì
	- 14	÷ 1	1	D3969-3	SPRING	1
		*				1
	15	14	4	AN3-14A	BOLT	
	16			AN3-16A	BOLT	Į
	17	*	2	AN3-20A	BOLT	
2	18	13	3	AN4-12	BOLT (DRILLED)	
	19	₹ 4	2	AN5-17A	BOLT	
à	20	ş	2	AN5-21A	BOLT	
		£ 3	3	AN310-4	NUT, CASTELLATED	
- 3		2	2	AN310C4	NUT, CASTELLATED	
		6	6	MS21042L3	NUT	
. : !		. 4	4	MS21042L5	NUT	
	25	₹ 3	3	MS24665-151	COTTER PIN	
á	26	2	2	MS24665-300	COTTER PIN	
-	27	6	6	NAS1149F0432P	WASHER	
	28	⊹ 4	4	NAS1149F0563P	WASHER	
	30	. 8	8	NAS1149F0332P	WASHER	
	- 31	2	2	NAS1149C0432R	WASHER	



D4030-041 LONG BASKET ASSY (350) (MESH SHOWN LOCALLY FOR CLARITY)

С

<u>D4030-043 LONG BASKET ASSY, LIGHT LID (350)</u> (MESH SHOWN LOCALLY FOR CLARITY)

С	(B8-1): C	OTY FOR	RITEM	#31 UNDER -043 WERE MISSING #3 WAS 4 (D6-1), ONLY 2 ARE SECTION C-C (D3-3).	мв	10.07.23				
В	AN5-21/	BOLT	WAS AN	I5-19A: BOM & (D3-3)	JPH	10.04.06				
A	NEW IS	SUE			JPH	10.03.16				
REV.			L	DESCRIPTION	BY	DATE				
DESIGN	ı	A	5	DART AEROSP	ACE L	TD				
DRAWN	1			HAWKESBURY, ONTAI		1				
CHECK	ED	-0	9	DRAWING NO.		REV. C				
MFG. A	PPR.	كآك	Str	D4030		SHEET 1 OF 3				
APPRO	VED	104	J	TITLE						
DE APP	R.	4	<i>t</i> .	LONG BASKET ASSY (350)NT						
DATE	10.0	7 23		COPYRIGHT © 2010 BY DART THIS DOCUMENT IS PREVATE AND CONFEDENTIAL AND IS SUPPL						

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

6

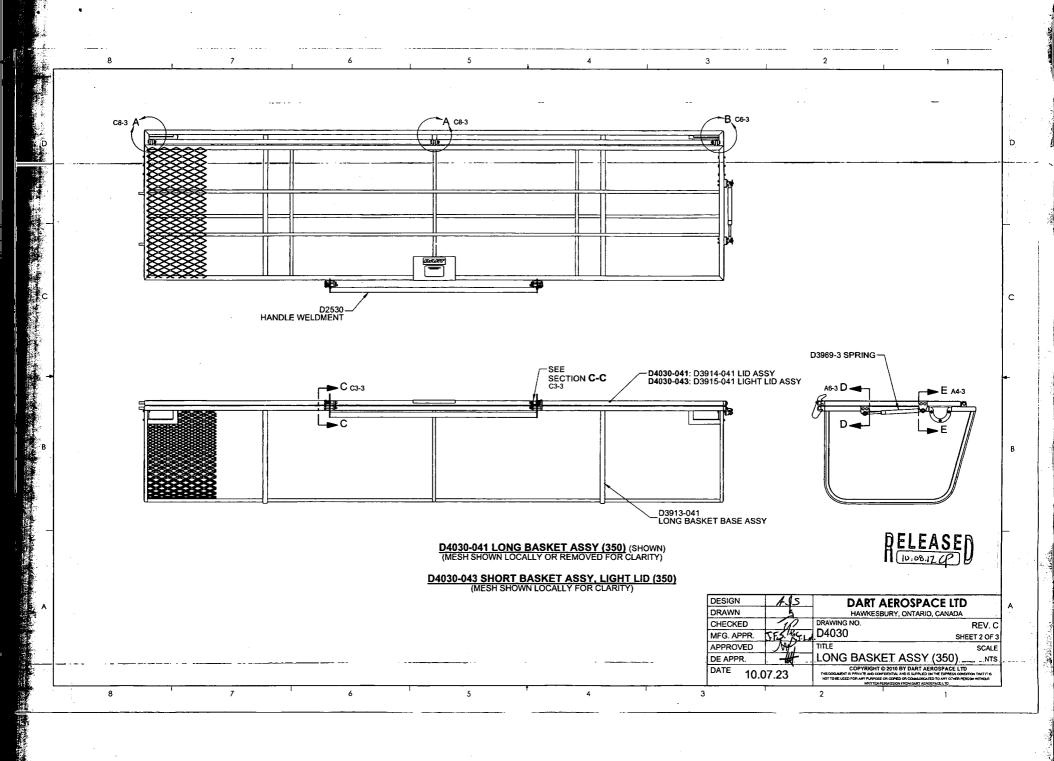
æ

NCR:	Yes /

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: ____Date: ____

WCIN. TO	.3 / 140				WORK ONDER NOW	.		,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,		QA Closed:	Date	::
Work Order					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No					Rework Scrap		ľ	Skid-tube Machining	Crosstube Small Fab	-1	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR No	D	<u></u>			Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	, Rec/stor	Supplier	
Root				Descri	iption of work order update	1	nitial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
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quip/Tooling												
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Supplier		1				-	,	•				
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Unapproved						L						
						FAUL	T CATE	GORY		·		
Landin	g Gear				General		_			_	_	
	Bending				Bend		Grain			Ovalized		Pressure/Forced
Γ	Centre N	ot Conce	ntric to (o/s	BOM/Route		Hardwa	ıre		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	ion Incomplete		Part Incorre	ct	Weld
Ī	Crushed/	Crimped		Г	Burrs		Instruct	tions Incomplete/	'Unclear	Part Lost/M	ssing	Wrong Stock Pulled
<u> </u>	Cuffs				Contamination		Mainte	enance		Part Moved	_	_
	Heat Treat				Countersink		Mislabe	eled		Positioned V	Vrong	
<u> </u>					Cut Too Short		Misread	đ		Power Loss/	Surge	Other
r	} ' ' }				Drill Holes		Offset				_	-
	Torque V		Extrusio	,	Drawing	Out of Calibration						
T T	Turning S				Finish		-	Sequence				
<u> </u>		•		—	Folio Outrido Dimensions							



												DQA:	Dat	:e: _		
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												QA Closed:	Dat	:e:		
						DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Work Orde	er:	. =				Rework	1		Skid-tube	Crosstube	_]	Water Jet	\neg	Engineering	
Part N	lo.				'	I			Machining Small Fab			Pro	d. Eng. Coor.	Quality		
raiti	٠٠.					· H I			Thermoforming Finishing			Rec/Store/Packaging			Other	
NCR N	lo.					Work Order Update				Composite		·	Supplier	$\overline{}$		
L												- 				
Root					Descri	ption of work order update		nitial	Ac	tion		Sign &		1		
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FAULT CATEGORY																
Landi	ng (Gear			_	General		-		•	_	-	,	_		
Bending						Bend	Grain	Grain			Ovalized		$\boldsymbol{\vdash}$	Pressure/Forced		
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardware			<u>_</u>	Over/Under	tolerance	${oldsymbol{ iny}}$	Temperature/Cure	
		Cracks				Broken/Damaged		Inspect	Inspection Incomplete			Part Incorre	ct	Ш	Weld	
		Crushed/	Crimped			Burrs		Instructions Incomplete/Unclear				Part Lost/M	ssing	Ш	Wrong Stock Pulled	
	Г	Cuffs				Contamination		Maintenance				Part Moved				

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

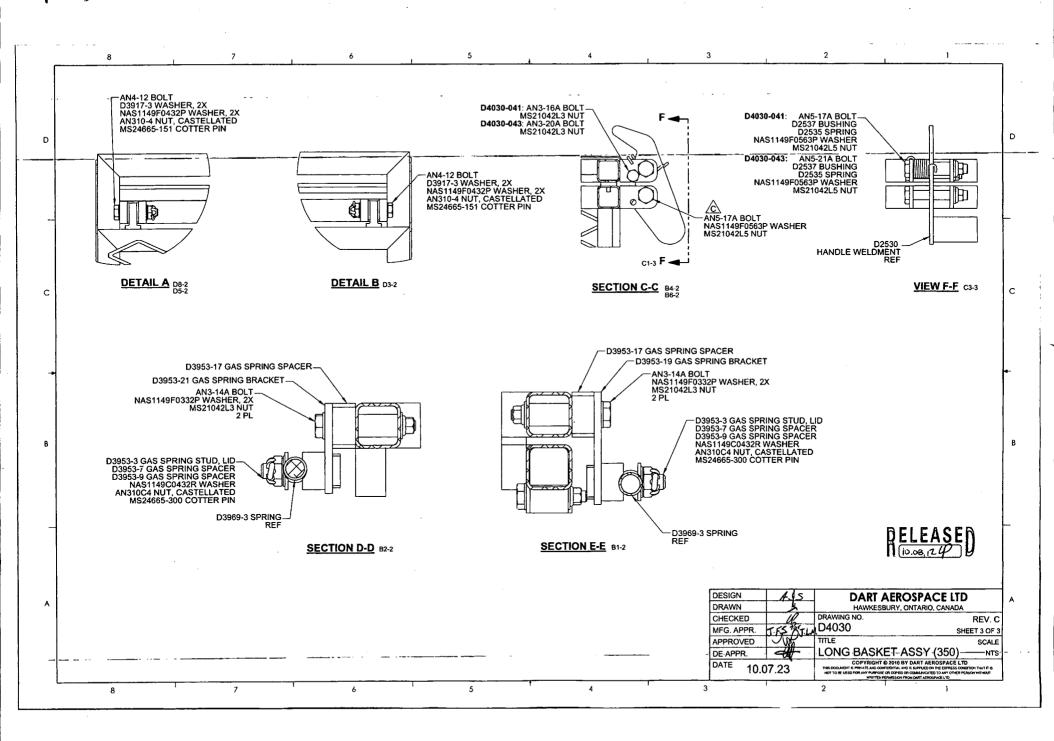
Wave/Twist in Tube

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion



											DQA:	Date	:			
NCR: Y	'es	/ No				WORK ORDER NON-C	O	NFORM	AANCE / UPDATE		•					
											QA Closed:	Date	:			
Work Orde	r.					DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Part N	- lo					Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube Machining Small Fal Thermoforming Finishin Large Fab Composite			ab ng	Prod Rec/Stor	Engineering Quality Other				
Root					Descri	ption of work order update		nitial	Action		Sign &	 				
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Description	Date	Verification	QC Inspector				
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Training																
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Landi	ng G	ear	and the same			General		-	•		-	<u></u>				
		Bending				Bend		Grain			Ovalized		Pressure/Forced			
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardware			Over/Under	tolerance	Temperature/Cure			
		Cracks				Broken/Damaged		Inspection Incomplete			Part Incorred	it _	Weld			
		Crushed/	Crimped			Burrs		Instructions Incomplete/Unclear			Part Lost/Mi	ssing	Wrong Stock Pulled			
		Cuffs				Contamination		Maintenance			Part Moved					
		Heat Trea	at			Countersink		Mislabeled			Positioned V	Vrong				
		Inspectio	n Strip in	Tube		Cut Too Short		Misread			Power Loss/	Surge	Other			
	П	Ripples in Bend				Drill Holes	Г	Offset		-	-	_				

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish